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D4956-39
Job Sheet 185108



Part No: D4956-39

Job Qty: 6 ea

Part Name: Wearplate Center Aft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEETS 7,8 IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	6 pcs		11/9/18	0.00	1.03	Waterjet 1		<i>2 18/10/2018</i>
120	QC	6 pcs		11/9/18	0.00	0.00	QC8		<i>OCT 29 2018 68</i>
130	Brake NC	6 pcs		11/9/18	0.21	0.24	Brake NC 1		<i>68</i>
140	QC	6 pcs		11/9/18	0.00	0.00	QC5		<i>NOV 12 2018 68</i>
150	HandFinish	6 pcs		11/9/18	0.00	0.34	HandFinish4		<i>18/11/13 68</i>
160	QC	6 pcs		11/9/18	0.00	0.00	QC3		<i>NOV 16 2018 68</i>
170	Packaging	6 pcs		11/9/18	0.00	0.00	Packaging3-2		<i>BED 18-11-16 89</i>
180	QC21-SA	6 Ea		11/9/18	0.00	0.00	QC21		<i>NOV 19 2018</i>
<i>ROCK GUARD H 138978 EX 11/19</i>									
<i>START 18/11/13</i>									
<i>FINISH 18/11/13</i>									

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	5.1000 sf (.85 ea)	100-Waterjet	<i>5090402</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M304S20GA	5	244	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	0.188Inches + 0.005 - 0.001	0.193 0.187	<i>9.192</i>	Diameter
2	Wearshoe	0.300Inches ± 0.010	0.310 0.290	<i>9.308</i>	
3	Wearshoe	0.300Inches ± 0.010	0.310 0.290	<i>9.306</i>	
4	Wearshoe	1.885Inches ± 0.010	1.895 1.875	<i>1.888</i>	
5	Wearshoe	2.000Inches ± 0.010	2.010 1.990	<i>2.002</i>	
6	Wearshoe	5.000Inches ± 0.030	5.030 4.970	<i>5.005</i>	
7	Wearshoe	14.000Inches ± 0.030	14.030	<i>14.000</i>	



Work Order update only

[illegible]

			13.970	
8	Wearshoe	33.000Inches $\pm$ 0.030	33.030 32.970	33,000
9	Wearshoe	6.750Inches $\pm$ 0.010	6.760 6.740	6,753
10	Wearshoe	11.500Inches $\pm$ 0.010	11.510 11.490	11,500
11	Wearshoe	16.250Inches $\pm$ 0.010	16.260 16.240	16,250
12	Wearshoe	19.750Inches $\pm$ 0.010	19.760 19.740	19,750
13	Wearshoe	21.750Inches $\pm$ 0.010	21.760 21.740	21,750
14	Wearshoe	25.250Inches $\pm$ 0.010	25.260 25.240	25,25
15	Wearshoe	27.775Inches $\pm$ 0.010	27.785 27.765	27,775
16	Wearshoe	31.275Inches $\pm$ 0.010	31.285 31.265	31,275
17	Wearshoe	34.775Inches $\pm$ 0.010	34.785 34.765	34,775
18	Wearshoe	36.820Inches $\pm$ 0.030	36.850 36.790	36,820

Plex 10/23/18 7:18 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					